

Date: Wednesday, 9/20/2006 3:24:10 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW KIT (19"X24")
 Job Number : 28671
 Estimate Number : 10323
 P.O. Number : N/A Part Number : K10008
 This Issue : 9/20/2006 S.O. No. : N/A Drawing Number : D2432 REV F3
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : F3
 Previous Run : 28340 Material : N/A
 Due Date : 9/27/2006 Qty: 9 Um: Each
 Written By :
 Checked & Approved By : 06 09 20
 Comment : Est Rev:J 04.02.17 Blank size changed KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile:
 K10008
 D206-559-013
 D350-578-011
 D427-659-011
 D315-670-011
 and create labels per PPP K10008
 CHG006(Bag Bluefiles separately)

9

Rs 06-09-21

2.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 6.8250 sf(s)/Unit Total : 54.6000 sf(s)
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: 10125-1 102164

bls

En 06/09/21 x 9 Kits

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

JF/S/ BG 06-09-21

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/20/2006 3:24:10 PM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F/EP/36 06-09-20

9

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

gml 06/09/20

9

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total: 20.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 6 D2182B050 Rubber Cushion 28042

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 D2274 Radius Block 28344
2 D2432F(ref only) Bearpaw 328671

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 6 D2438 Clamp 328345

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/20/2006 3:24:11 PM
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Drawing Name: BEARPAW KIT (19"X24")

Job Number: 28671

Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : ~~96.0000~~ ¹⁰⁸ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 D2529 Washer B27876

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4166 f(s)/Unit Total : ^{3.15} 3.3328 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 6 D2732-050 Rubber Cushion B26472

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : ¹⁰⁸ ~~96.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 AN4-15A Bolt M102039

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : ¹⁰⁸ ~~96.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 AN4-17A Bolt M101124

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : ~~192.0000~~ Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 24 AN960JD416 Washer M19185

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RD Date: 06/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M19099

RV 6/9/26 (9)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



RV 06/09/26 (9)

Comment: INSPECT 100% KITS FOR COMPLETENESS

RV 06/09/26 (9)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10008

Location: RVE

RV 6/9/27 (9)

RV 06/09/27 (9)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



(9)

Comment: FINAL INSPECTION/W/O RELEASE

RV 06/09/27

Job Completion



RV 06/09/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	28671
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

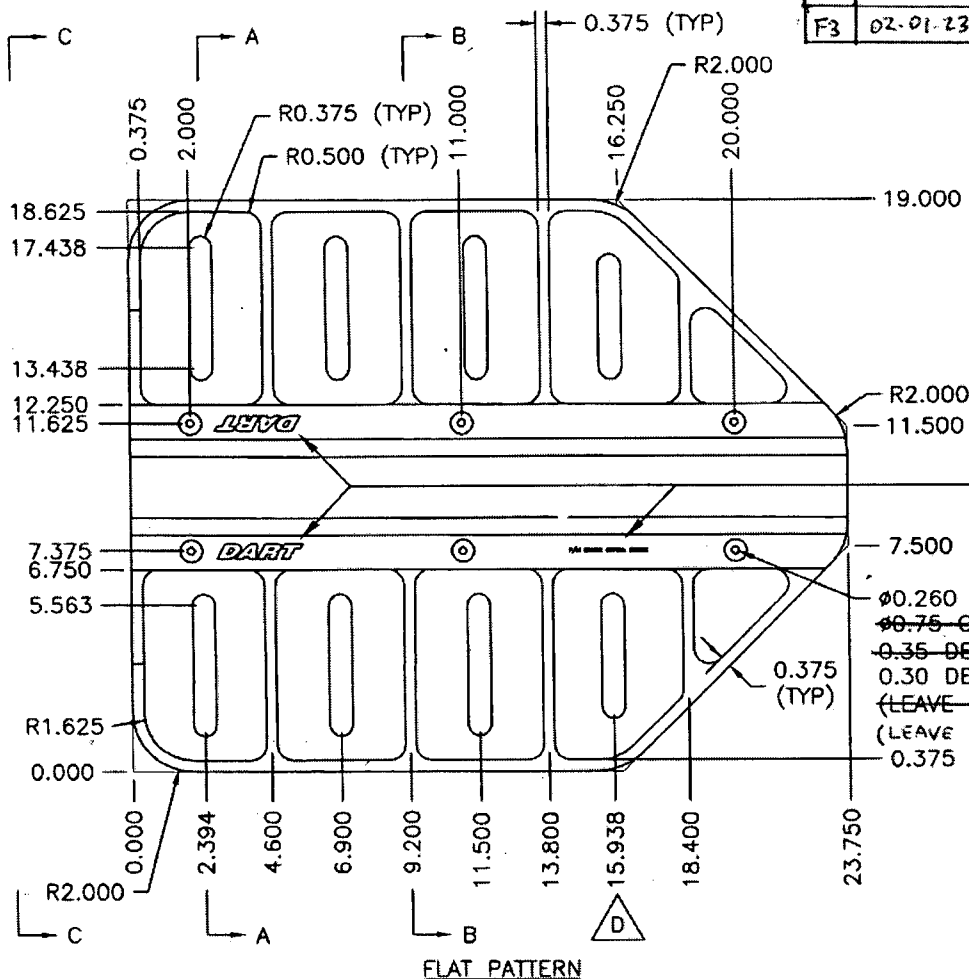
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063				
B	5.500	+/-0.030	5.400				
C	0.200	+/-0.030	.193				
D	0.25 x 45°	+/-0.030	.230				
E	R0.250	+/-0.030	.250				
F	0.250	+/-0.010	.245				
G	0.625	+/-0.030	.620				
H	0.375	+/-0.010	.375				
I	0.950	+0.030/0.010	.945				
J	19.000	+/-0.030	19.000				
K	3.14	+/-0.030	3.140				
L	3.28	+/-0.030	3.280				
M	Ø0.260	+0.005/-0.000	.260				
N	Ø0.93	+/-0.030	.927				
O	0.30	+0.030/-0.000	.308				
P	23.750	+/-0.030	23.750				
Q	7.375	+/-0.030	7.375				
R	4.250	+/-0.010	4.240				
S	2.000	+/-0.030	2.015				
T	9.000	+/-0.010	9.000				
U	9.000	+/-0.010	9.000				
V	0.375	+/-0.010	.385				

Measured by: BG	Audited by: JML	Prototype Approval:	N/A
Date: 06-09-21	Date: 06/09/22	Date:	JMA

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	JF

RELEASED
98-06-17 KGE

F1	99.03.03	ADD DEC 9143
F2	01.03.28	0.93 WAS 0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF



ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2432	REV. F
DATE 98.05.12		TITLE BEARPAW	SHEET 1 OF 2
A	95.10.31	NEW ISSUE	SCALE 1:6
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

EFFECTIVE DEOS

9143

BEND AFTER MACHINING
(D2432B ONLY)

0.950 (REF)

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

SHOP COPY MAT
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

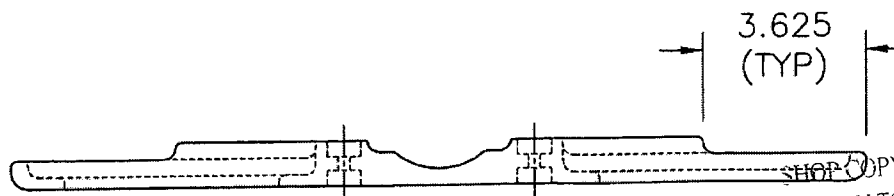
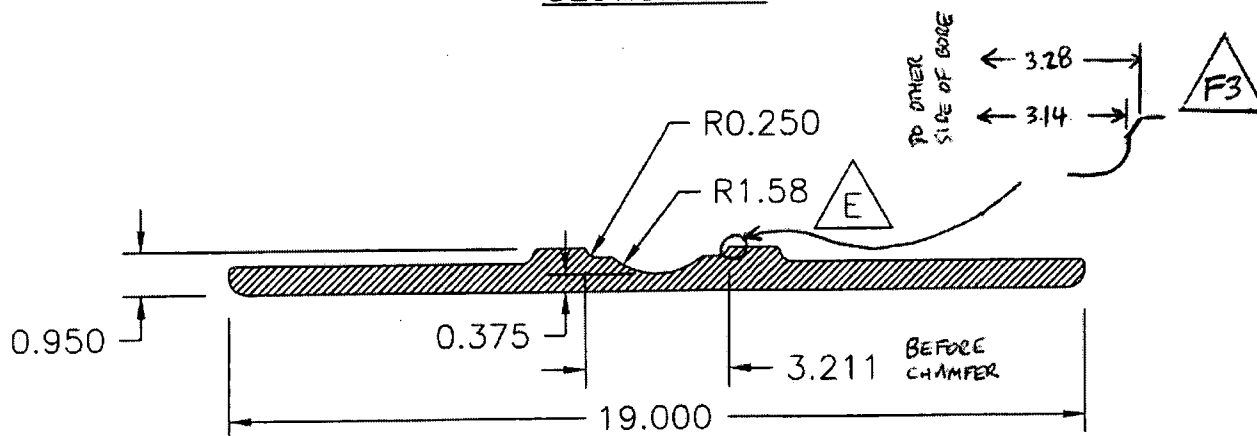
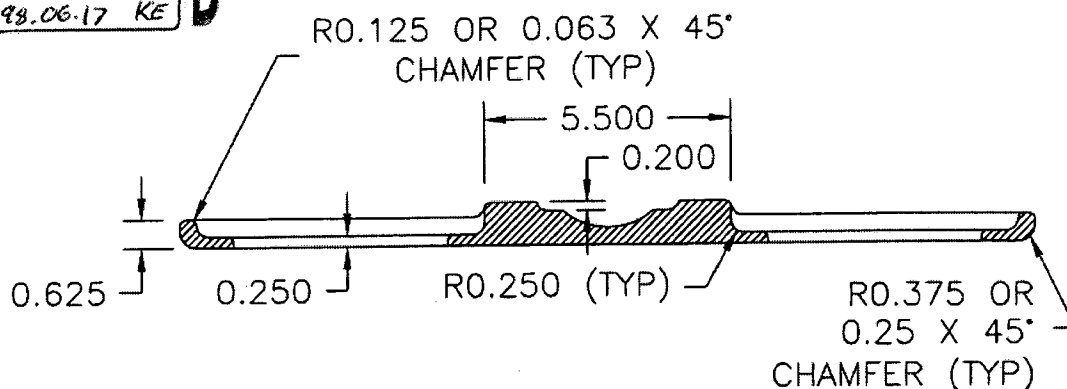
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WORK ORDER
NO. 2867



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED
98.06.17 KE



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WITHOUT NOTICE
WORK ORDER
NO. 28671